

Work Order ID 72788

Friday, August 12, 2011 2:39:32 PM



Page 1

Item ID: D2721-041

Accept



Setup Start



Revision ID:

Item Name: 206B Step Assembly

Stop



Start Date: 8/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-08-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2721	Rev C								

100.

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2721-1 using D2622 extrusion as per Dwg D2721
Deburr and bevel ends for welding

11-10-17

2

φ

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT
followed by Jig DT

11-10-18

2

φ

A/R AL Rod Batch: *118735*

114514

Grind end cap welds flush

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

2 0 BEA/10/18

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sul/10/19

12
44

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2X PM-11/10/19
LH

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BR 11-10-20

160

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2721 using Jig DT
Jig DT

followed by

A/R AL Rod Batch: 114314

Grind End Cap Welds Flush

2 φ

11-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






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Item Name: 206B Step Assembly
Start Date: 8/12/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 8/19/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC9 - Inspect visual per QS1004- Fusion Welds Memo	0.00 0.00		Sub 121				P10 →	
180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sub 124				(K2 W4)	
190  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00						2x DM 7/10/21 LH	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/10/21	#170	Change to QC 10 inspection					S 11/10/21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
3200F
9:30

2X0
M-L 11/10/24

210

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

LH 2 BR 11-10-24

220

Wing Walk as per dwg QSI005 4.4 Batch 118988

0.00



HandFinish

Hand Finishing

Memo

0.00

2 - BR 11-10-24

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Friday, August 12, 2011 2:39:32 PM

Page 6

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Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230 QC3- Inspect Part Finish 0.00



QC

Memo

0.00

Quality Control

241 of 11 11/10/2011

240 Identify as per dwg & Stock Location: _____ 0.00



Packaging

Memo

0.00

Packaging

7775323 SF

250 QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/10/2011

MF
11-10-2011

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, August 12, 2011 2:39:38 PM

Page 1

Work Order ID: 72788

Parent Item: D2721-041

Parent Item Name: 206B Step Assembly

Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing
walk DD 10.02.24 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

100

Each

83.7000

1

2



Step Extrusion

Location

Loc Qty

Loc Code

HALL

372131

74

64409

6

68293

68

WA

1

9.7

46910

2

66970

7.7

2

D2734

Manufactured No

110

Each

47.0000

1

2



Step End Plate

Location

Loc Qty

Loc Code

WA

373196

47

70701

47

2

D3461-1

Manufactured No

110

Each

52.0000

1

2



Mounting Plate

Location

Loc Qty

Loc Code

WA017

52

41600

6

58756

46

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, August 12, 2011 2:39:38 PM

Page 2

Work Order ID: 72788

Parent Item: D2721-041

Parent Item Name: 206B Step Assembly

Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 2.00

Required Qty: 2.00

D3461-3

 Mounting Plate

Manufactured No

110 Each

9.0000

1 2



8/11.10.17

Location

Loc Qty

Loc Code

WA017

9

41601

9

2

D3461-5

 Mounting Plate

Manufactured No

110 Each

25.0000

1 2



8/11.10.17

Location

Loc Qty

Loc Code

WA017

25

33862

25

2

D3461-7

 Mounting Plate

Manufactured No

110 Each

27.0000

1 2



8/11.10.17

Location

Loc Qty

Loc Code

WA017

27

33863

27

2

D2734

 Step End Plate

Manufactured No

160 Each

47.0000

1 2



8/11.10.20

Location

Loc Qty

Loc Code

WA

373196

47

70701

47

2

Friday, August 12, 2011 2:39:38 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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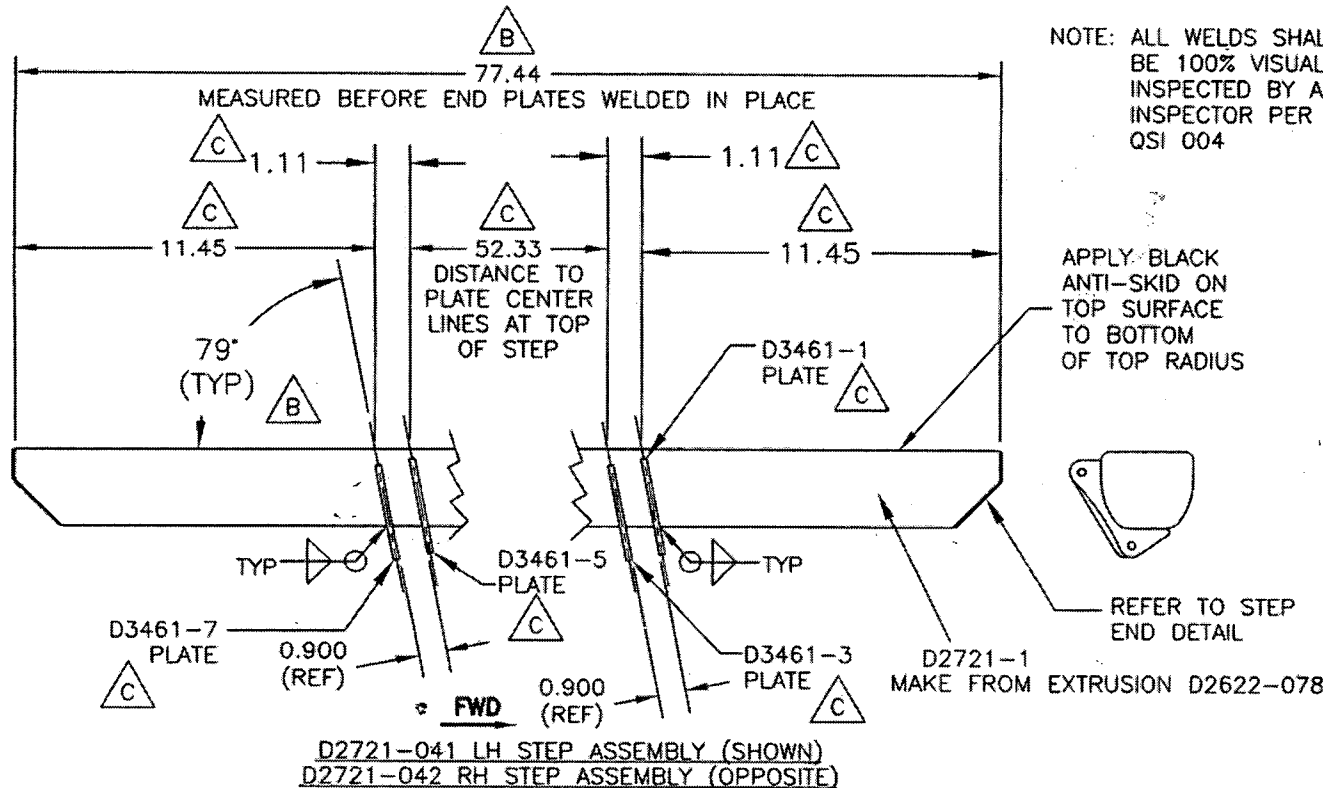
NOTE: Date & initial all entries



RELEASED
05.11.14

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2721	REV. C
			206B STEP ASSEMBLY	SHEET 1 OF 1
				SCALE
				NTS

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



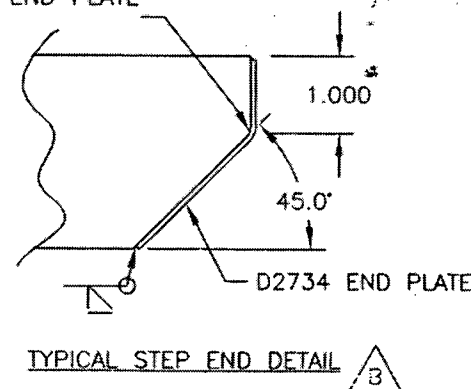
ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	X	D2721-041	LH STEP ASSEMBLY
		D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 111-8810